



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**RB T101530-13**  
**Job Sheet 180989**



Part No: RB T101530-13

Job Qty: 8 ea

Part Name: Base



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 7/19/18

Job Tracking No:

Due Date: 8/9/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RB T101530 Rev.A IPP Rev. A 18.05.29 new issue DP Verify DD/IPP Rev. B 18.07.04 new DWG. DP Verify DD

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |                    |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 90    | Start up Operation | 8 Ea  | 8/9/18     | 8/9/18   | 0.00      | 0.00    | Start Up Machining-3  |           |          |
| 110   | CNC Lathe          | 8 pcs | 8/9/18     | 8/9/18   | 0.00      | 0.80    | MORI SL2500Y          |           |          |
| 120   | QC                 | 8 pcs | 8/9/18     | 8/9/18   | 0.00      | 0.00    | QC2 Machining-4       |           |          |
| 130   | QC                 | 8 pcs | 8/9/18     | 8/9/18   | 0.00      | 0.00    | QC8 Machining-4       |           |          |
| 140   | Outsource          | 8 pcs | 8/9/18     | 8/9/18   | 0.00      | 0.00    | Outsource12           |           |          |
| 150   | Packaging          | 8 pcs | 8/9/18     | 8/9/18   | 0.00      | 0.00    | Packaging2            |           |          |
| 160   | QC                 | 8 pcs | 8/9/18     | 8/9/18   | 0.00      | 0.00    | QC6                   |           |          |
| 210   | Packaging          | 8 pcs | 8/9/18     | 8/9/18   | 0.00      | 0.00    | Packaging3-1          |           |          |
| 220   | QC21-SA            | 8 Ea  | 8/9/18     | 8/9/18   | 0.00      | 0.00    | QC21                  |           |          |

Part Op 110 - 1-Machine as per DWG. FC202 FOLIO REV: AA DWG REV: A 2-Debur  
Descriptions: 140 - -Issue P/O to GROUPE ALTECH; PO 042888 Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required

### Job BOM

| Part / Item      | Component Name                                            | Quantity           | Operation             | Container |
|------------------|-----------------------------------------------------------|--------------------|-----------------------|-----------|
| MT-4140QT-R1.125 | AISI 4140 Quenched & Tempered Steel Round Bar 1.125" Dia. | .9680 ft (.121 ea) | 90-Start up Operation | 5053644   |

### Job Allocations

| Operation             | Component Part   | Required | Inventory | Allocated |
|-----------------------|------------------|----------|-----------|-----------|
| 90-Start up Operation | MT-4140QT-R1.125 | 1        | 17        | 0         |



Container No: S134090

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL: 1 613 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

### Specifications

Specifications could not be found.

Part: RB T101530-13  
Job No: 180989  
Serial No/Batch: S134090

Revision: A  
Inspector:  
Exp Date:  
Instructions:

Date: 12/03/18

Plex 10/29/18 7:43 AM dart.lacelle.linda

8 7 6 5 4 3 2 1

D

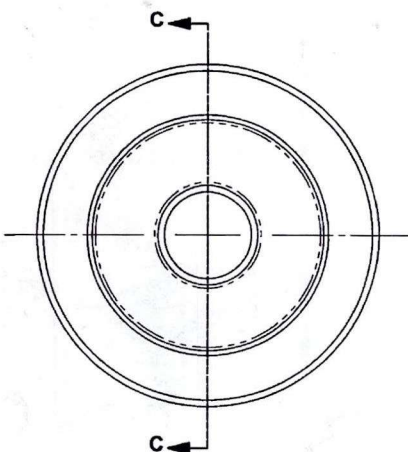
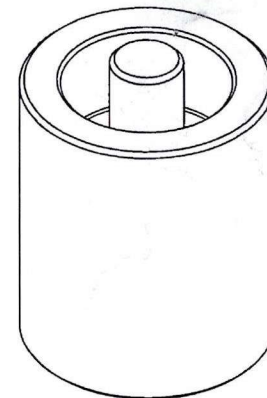
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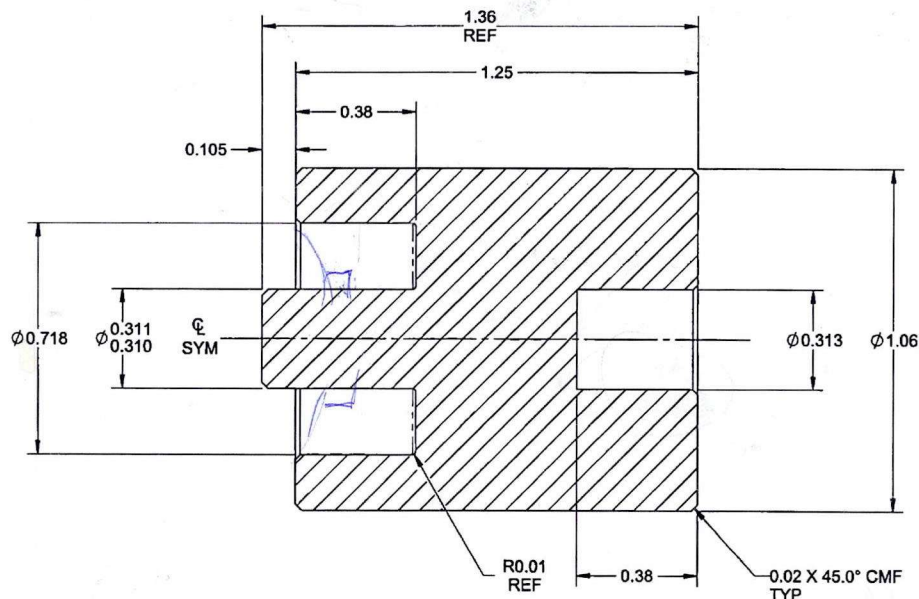
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C

B



**RB T101530-13 BASE**



**SECTION C-C**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 180988 MLC  
187029

**NOTES:**

- 1) MATERIAL: 4140/4142 (28-32 RC) OR 17-4 PH-H900-H1150 STAINLESS STEEL
- 2) HEAT TREAT: N/A
- 3) FINISH: 17-4PH: N/A  
4140/4142: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"  
X.XX = +/- 0.01" / +/- 0.5"  
X.XXX = +/- 0.005" / +/- 0.1"  
X.XXXX = +/- 0.0005" / +/- 0.05"  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A

|                                                                                                                                                                                                                                                                          |            |                                                          |               |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------|----------------------------------------------------------|---------------|
| DESIGN                                                                                                                                                                                                                                                                   | KK         | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |               |
| DRAWN                                                                                                                                                                                                                                                                    | KK         |                                                          |               |
| CHECKED                                                                                                                                                                                                                                                                  | <i>MLC</i> | TOOL PART #                                              | REV. A        |
| MFG. APPR.                                                                                                                                                                                                                                                               | DP         | RB T101530                                               | SHEET 7 OF 10 |
| APPROVED                                                                                                                                                                                                                                                                 | <i>MLC</i> | TITLE                                                    | SCALE         |
| DATE                                                                                                                                                                                                                                                                     | 7/4/2018   | BEARING ROLLER TOOL (-3/-5)                              | NTS           |
| COPYRIGHT © 2018 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. |            |                                                          |               |

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Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

# PURCHASE ORDER PO042578



**Supplier:** GRO002-VC  
Group Altech  
2455 Halpern  
St Laurent  
QC  
H4S 1N9 Canada  
Phone: 514-335-3666  
Fax: 514-335-3868

**PO No:** PO042578

**PO Date:** 2/12/19

**Due Date:** 2/19/19

**Purchase Order**

**Revision:**

**Revision Date:**

**Ship-To Contact:** Tsimiklis, ChrisoulaPhone:

**Ship To:** 1270 Aberdeen Street  
Hawkesbury  
ON  
K6A 1K7 Canada  
Phone: 613-632-5200

**Via:** Ground

**Pynt Terms:** Net 60

**Freight Terms:**

**Special Comments:** \*\* need lines 1&2 asap if possible \*\*

## Items

| Line Item | Job    | Part            | Description                                                                                                                                                                                                                                                                                               | Status | Account | Due Date | Order Quantity | Received Quantity | Balance | Unit Price (CAD) | Extended Price |
|-----------|--------|-----------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------|---------|----------|----------------|-------------------|---------|------------------|----------------|
| 1         | 180989 | RB T101530-13   | Base<br>-Issue P/O to GROUPE ALTECH;<br>PO<br>-Black oxide finish, MIL-C-13924C Class 1<br>-Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess.<br>-Material type; 4140<br>-Certificate of Conformity is required | Firmed | -       | 2/15/19  | 6 pcs          | 0 pcs             | 6 pcs   | \$3.52941/pcs    | \$21.18        |
| 2         | 188696 | RB6796941-201-3 | Plug<br>Outsource12 (Outside Processing - Black Oxide)<br>-Issue P/O to Groupe Altech;<br>PO<br>-Black oxide finish, MIL-C-13924C Class 1<br>-Certificate of Conformity is required                                                                                                                       | Firmed | -       | 2/15/19  | 12 pcs         | 0 pcs             | 12 pcs  | \$3.52941/pcs    | \$42.35        |



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# PURCHASE ORDER

## PO042578



### Items

| Line Item | Job      | Part                 | Description                                                                                                                                                                                                                                                                                               | Status | Account | Due Date | Order Quantity | Received Quantity | Balance | Unit Price (CAD) | Extended Price |
|-----------|----------|----------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------|---------|----------|----------------|-------------------|---------|------------------|----------------|
| 3         | 189209   | RBE350A93-3202-00-23 | Washer<br>-Issue P/O;<br><br>-Black oxide finish, MIL-C-13924C Class 1<br>-Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess.<br>-Material type; DOM<br>-Certificate of Conformity is required                   | Firmed | -       | 2/19/19  | 14 pcs         | 0 pcs             | 14 pcs  | \$3.52941/pcs    | \$49.41        |
| 4         | 180989-A | RB T101530-13        | Base<br>-Issue P/O to GROUPE ALTECH;<br>PO<br>-Black oxide finish, MIL-C-13924C Class 1<br>-Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess.<br>-Material type; 4140<br>-Certificate of Conformity is required | Firmed | -       | 2/19/19  | 2 pcs          | 0 pcs             | 2 pcs   | \$3.52941/pcs    | \$7.06         |

Grand Total: \$120.00

### Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit [www.dartaerospace.com](http://www.dartaerospace.com) for further explanation.

Plex 2/13/19 8:23 AM dart.tsimiklis.chrisoula





## Certificat de Conformité / Certificate of Compliance

(016796-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9  
 Tel: 514-335-3666 Fax: 514-335-3868  
 www.groupaltech.com

## Bon de Livraison / Packing Slip

016796 - 1

Livré à / Ship to

**DART AEROSPACE LTD**  
 1270 ABERDEEN STREET  
 HAWKESBURY, ON, K6A1K7  
 CANADA  
 Tel.: 613-632-5200 Fax.:

Client / Customer:

**DART AEROSPACE LTD**  
 1270 ABERDEEN STREET  
 HAWKESBURY, ON, K6A1K7  
 CANADA  
 BUYER:

| Date expédition<br>Ship date |                                                                            | Créé Par<br>Generated By                                                                                                                     | Transport / No de Compte<br>Courier / Acc. No. | Bon de commande Client<br>Customer Purchase Order No. |                 |                   |               |                        |
|------------------------------|----------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------|-------------------------------------------------------|-----------------|-------------------|---------------|------------------------|
| 18-Feb-2019                  |                                                                            | Aman                                                                                                                                         |                                                | 042578                                                |                 |                   |               |                        |
| #Ligne<br>Line#              | No. de Série / # Pièce<br>Part Number / Line Item Details<br>Job # / Ref # | Description pièce(s)                                                                                                                         | CATG.<br>U/M                                   | Comm.<br>/Ordered                                     | Exp/<br>Shipped | Qté NC/<br>NC Qty | Qté<br>Scrap/ | À venir/<br>Back Order |
| 1                            | RBT101530-13<br>Rev.                                                       | RBT101530-13<br>01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL ]<br>MIL-C-13924C CLASS 1<br>APPLY A THIN LAYER OF OIL<br>WIPE OFF EXCESS           | OXIDE-BLACK<br>CH                              | 2                                                     | 2               | 0                 | 0             | 0                      |
| 2                            | RB6796941-201-3<br>Rev.                                                    | PLUG<br>BLACK OXIDE<br>MIL-C-13924C CLASS 1                                                                                                  | BLACK-OXIDE<br>CH                              | 12                                                    | 12              | 0                 | 0             | 0                      |
| 3                            | RBE350A93-3202-00-23<br>Rev.                                               | RBE350A93-3202-00-23<br>01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL ]<br>MIL-PRF-13924C CLASS 1<br>APPLY A THIN LAYER OF OIL<br>WIPE OFF EXCESS | OXIDE-BLACK<br>CH                              | 14                                                    | 14              | 0                 | 0             | 0                      |
| 4                            | RBT101530-13<br>Rev.                                                       | RBT101530-13<br>01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL ]<br>MIL-C-13924C CLASS 1<br>APPLY A THIN LAYER OF OIL<br>WIPE OFF EXCESS           | OXIDE-BLACK<br>CH                              | 6                                                     | 6               | 0                 | 0             | 0                      |

Notes Additionnelles / Additional Notes

Epaisseur réelle  
Actual Thickness

Inspecteur Qualité  
Quality Inspector

Réçu par  
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.  
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.  
 Our financial and legal responsibility will not be higher than the amount of invoice.